

Work Order ID 145855***145855***

Page 1

Item ID: D350-749-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Low to High Gear Conversion

Start Date: 4/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-749	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP350-749-015 CHG 001 "NO DART ARC OR C OF C REQUIRED"								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAY 12 2016
DAS 6 9-89
JUN 03 2016

JUN 03 2016

MAY 12 2016
DAS 6 9-89
DAS 28 9-89

JUN 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 145855***145855***

Page 2

Friday, May 06, 2016 10:56:44 AM

Item ID: D350-749-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Low to High Gear Conversion
Start Date: 4/14/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/5/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-749-015								
	Location : FG121								
	PPP Rev: _____								
	"NO DART ARC OR C OF C REQUIRED"								
	ATTN: ALL ORIGINAL EUROCOPTER ARC AND TAGS TO BE SHIPPED WITH KIT								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

BAS
27
9-89
JUN 03 2016

MCS JUN 03 2016

MCS JUN 03 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Friday, May 06, 2016 10:56:42 AM

Page 1

Work Order ID: 145855

145855

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 4/14/2016

Required Date: 5/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-02-14 DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
350A41-1088-20 *350A41-1088-20* Strip, Chafing, Upper		Purchased	No			110	Each	8.0000	4	4		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>						
				ST594			8						
				m132111			4						
				m134538			4						
350A41-1090-20 *350A41-1090-20* Strip, Chafing, Lower Front		Purchased	No			110	Each	4.0000	2	2		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>						
				ST595			4						
				m132111			2						
				m134538			2						
350A41-1089-20 *350A41-1089-20* Strip, Chafing, Lower Rear		Purchased	No			110	Each	4.0000	2	2		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>						
				ST594			4						
				m132111			2						
				m134538			2						
350A41-1092-22 *350A41-1092-22* Half Clamp		Purchased	No			110	Each	4.0000	4	4		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>						
				ST595			4						
				m134494			4						

MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						OTHER : ☐	

Picklist Print

Page 2

Friday, May 06, 2016 10:56:42 AM

Work Order ID: 145855

145855

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 4/14/2016

Required Date: 5/5/2016

Start Qty: 1.00

Required Qty: 1.00

22201TK080018X Purchased

No

110

Each

4.0000

2

2

**

DAS

6

9-89

DAS

28

9-89

22201TK080018X

SCREW

DAS

27

9-89

Location

Loc Qty

Loc Code

ST567

4

m132111

4

23112TK080X

Purchased

No

110

Each

4.0000

2

2

**

DAS

6

9-89

DAS

28

9-89

23112TK080X

WASHER

DAS

27

9-89

Location

Loc Qty

Loc Code

ST578

4

m134494

4

ASN52320BH120N

Purchased

No

110

Each

6.0000

2

2

**

DAS

6

9-89

DAS

28

9-89

ASN52320BH120N

NUT

DAS

27

9-89

Location

Loc Qty

Loc Code

ST556

6

120055

2

121159

4

22201TK060070X

Purchased

No

110

Each

4.0000

2

2

**

DAS

6

9-89

DAS

28

9-89

22201TK060070X

SCREW

DAS

27

9-89

Location

Loc Qty

Loc Code

ST567

4

m132111

4

MAY 14 2016

Friday, May 06, 2016 10:56:42 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY						
Environment ☐	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____						
Misidentified ☐	☐	Past Due							

REFERENCE ONLY

Qty -011	Qty -013	Qty -016	Qty -021	Qty -023	Qty -031	Qty -033	Part Number	Description
X							D350-748-011	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE
	X						D350-748-013	LANDING GEAR KIT HIGH, AIRCUISEIR / DART TRI-BAG FLOAT COMPATIBLE
		X					D350-748-016*	STANDARD TO HIGH GEAR CONVERSION KIT
			X				D350-748-021	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
				X			D350-748-023	LANDING GEAR KIT HIGH, AIRCUISEIR / DART TRI-BAG FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
					X		D350-748-031	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
						X	D350-748-033	LANDING GEAR KIT HIGH, AIRCUISEIR / DART TRI-BAG FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
1	1		1	1	1	1	D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
1	1		1	1	1	1	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1							D350-636-011	SKIDTUBE INSTALLATION, LH, STD
1							D350-636-012	AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
	1						D350-636-013	SKIDTUBE INSTALLATION, RH, STD
	1						D350-636-014	AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			1				D350-636-015	SKIDTUBE INSTALLATION, LH, STD
			1				D350-636-016	AIRCUISEIR/DART TRI-BAG FLOAT COMPATIBLE
				1			D350-636-017	SKIDTUBE INSTALLATION, RH, STD
				1			D350-636-018	AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
					1		D350-636-215	SKIDTUBE INSTALLATION, LH, STD
					1		D350-636-216	AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
						1	D350-636-217	SKIDTUBE INSTALLATION, RH, STD
						1	D350-636-218	AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
								SKIDTUBE INSTALLATION, LH
								AIRCUISEIR/DART TRI-BAG FLOAT COMPATIBLE DELUXE
								SKIDTUBE INSTALLATION, RH
								AIRCUISEIR/DART TRI-BAG FLOAT COMPATIBLE DELUXE
		4					350A41-1088-20	STRIP, CHAFING, UPPER
		2					350A41-1090-20	STRIP, CHAFING, LOWER, FRONT
		2					350A41-1089-20	STRIP, CHAFING, LOWER, REAR
		4					350A41-1092-22	HALF, CLAMP
		2					22201TK080018X	SCREW
		2					23112TK080X	WASHER
		2					ASN52320BH120N	NUT
		2					22201TK060070X	SCREW

*ADDITIONAL PARTS ARE REQUIRED WHEN SWITCHING FROM STANDARD TO HIGH GEAR ON AS350/355 AIRCRAFT. CUSTOMERS WHO ARE SWITCHING FROM STANDARD TO HIGH GEAR CAN PROCURE THE D350-748-015 CONVERSION KIT.

D	ADD -111/-113/-121/-123/-131/-133	CP	15.05.28
C	ADD -021/-023/-031/-033 KITS	RF	11.09.28
B	ADD D350-748-015 KIT FOR STANDARD TO HIGH GEAR CONVERSION	PH	08.02.08
A	NEW ISSUE	CP	08.09.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	N/A	D350-749	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LANDING GEAR KITS	NTS
DATE	15.05.28	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	